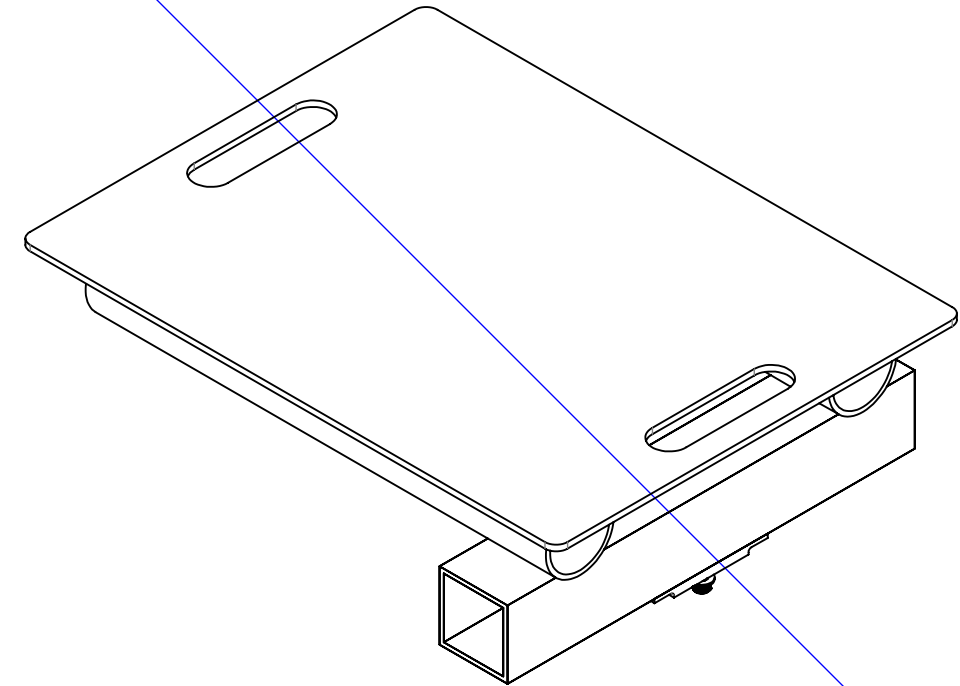
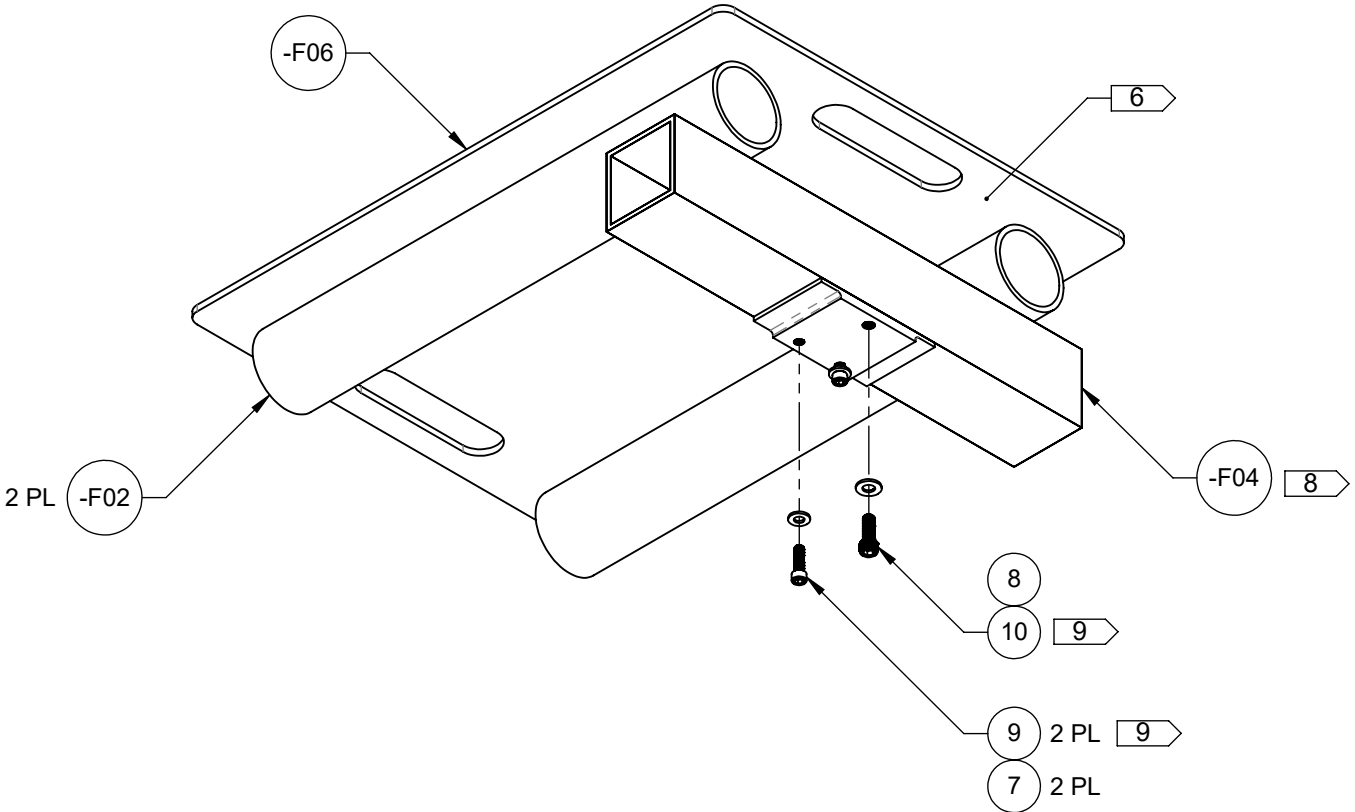


ITEM	QTY	P/N	DESCRIPTION
-F02	2	RBT18640-101-F02	TUBE
-F04	1	RBT18640-101-F04	ADAPTER PLATE ASSEMBLY
-F06	1	RBT18640-101-F06	PLATE
7	2	NAS1149F0563P	WASHER
8	1	NAS1149F0663P	WASHER
9	2	NAS1352-5-16P	SOCKET HEAD CAP SCREW
10	1	NAS1352-6-16P	SOCKET HEAD CAP SCREW



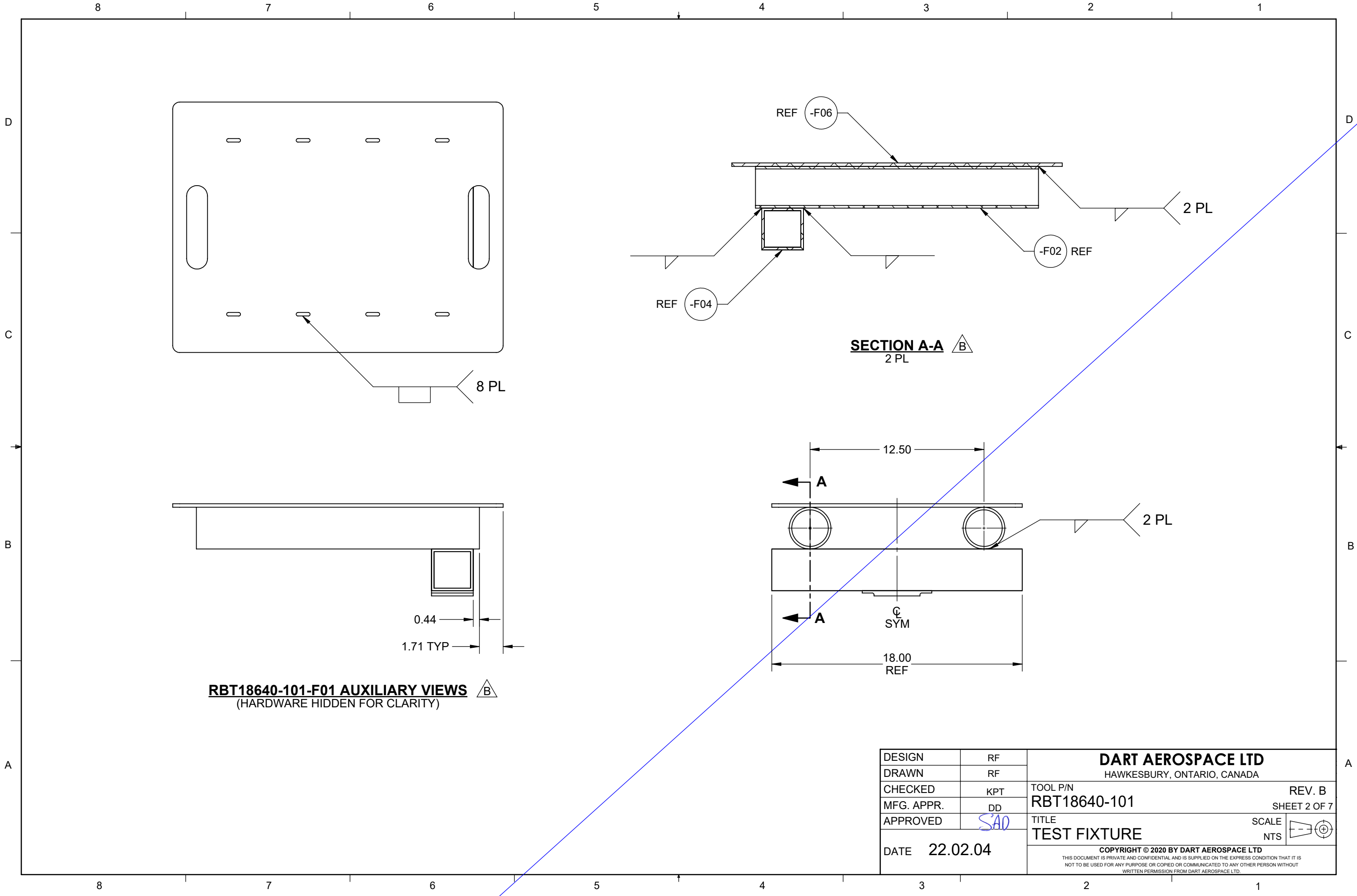
RBT18640-101-F01 ENGINE REMOVAL ADAPTER ASSEMBLY




NOTES:

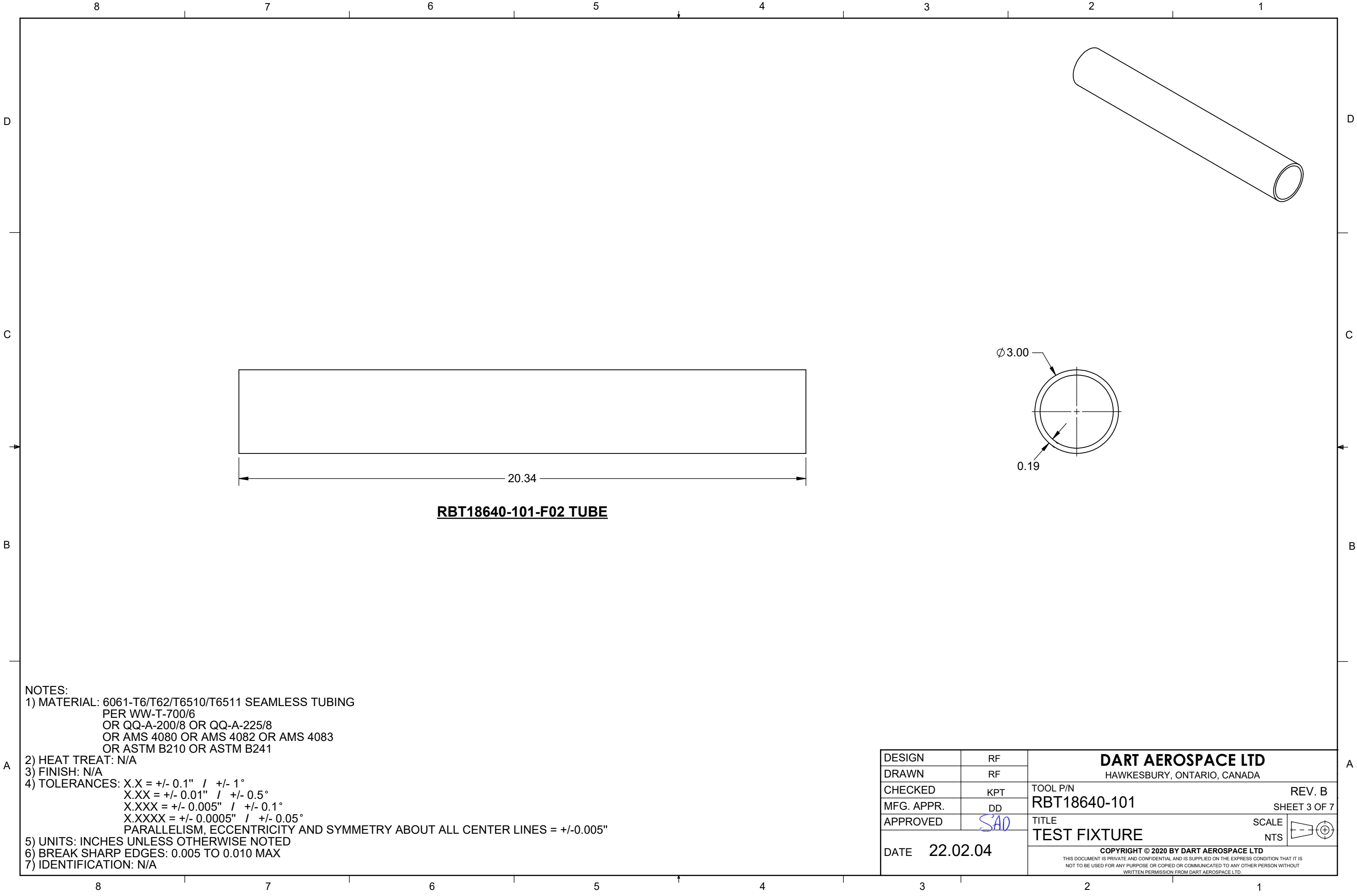
- 1) MATERIAL: N/A
- 2) FINISH: PRIME PER DART QSI 005 SECTION 4.2.1 OR USING ANY MIL-PRF-23377/MIL-PRF-85582 PRIMER
PAINT RED PER DART QSI 005 SECTION 4.2.2 OR USING ANY MIL-PRF-85285/MIL-PRF-83286 PAINT
- 3) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "RBT18640-101-F01" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 24.43 lbs
- 8) MASK HELICOILS PRIOR TO PRIME AND PAINT
- 9) INSTALL SOCKET HEAD CAP SCREWS HAND-TIGHT; MINIMUM OF 3 THREADS IN ENGAGEMENT

B	-F01 REMOVED -F03 FROM BOM. ADDED ITEMS 7 TO 10. REVISED FINISH AND TOLERANCE NOTES. ADDED NOTE 9. REVISED WELDMENT VIEWS. -F04 REVISED TO BE A WELDMENT. REVISED SIZES OF HELICAL INSERTS. ADDED NOTE 8. -F05 MOVED HELICOIL HOLES TO -F04 WELDMENT -F06 REVISE DIMENSION LOCATION AND QUANTITIES	HB ECR 392	RF
A	NEW ISSUE	HB ECR 60	RF
REV.	DESCRIPTION	ECN #	BY
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	KPT	TOOL P/N	REV. B
MFG. APPR.	DD	RBT18640-101	SHEET 1 OF 7
APPROVED	SAD	TITLE	SCALE
DATE 22.02.04		TEST FIXTURE	NTS
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RBT18640-101-F01 AUXILIARY VIEWS 
(HARDWARE HIDDEN FOR CLARITY)

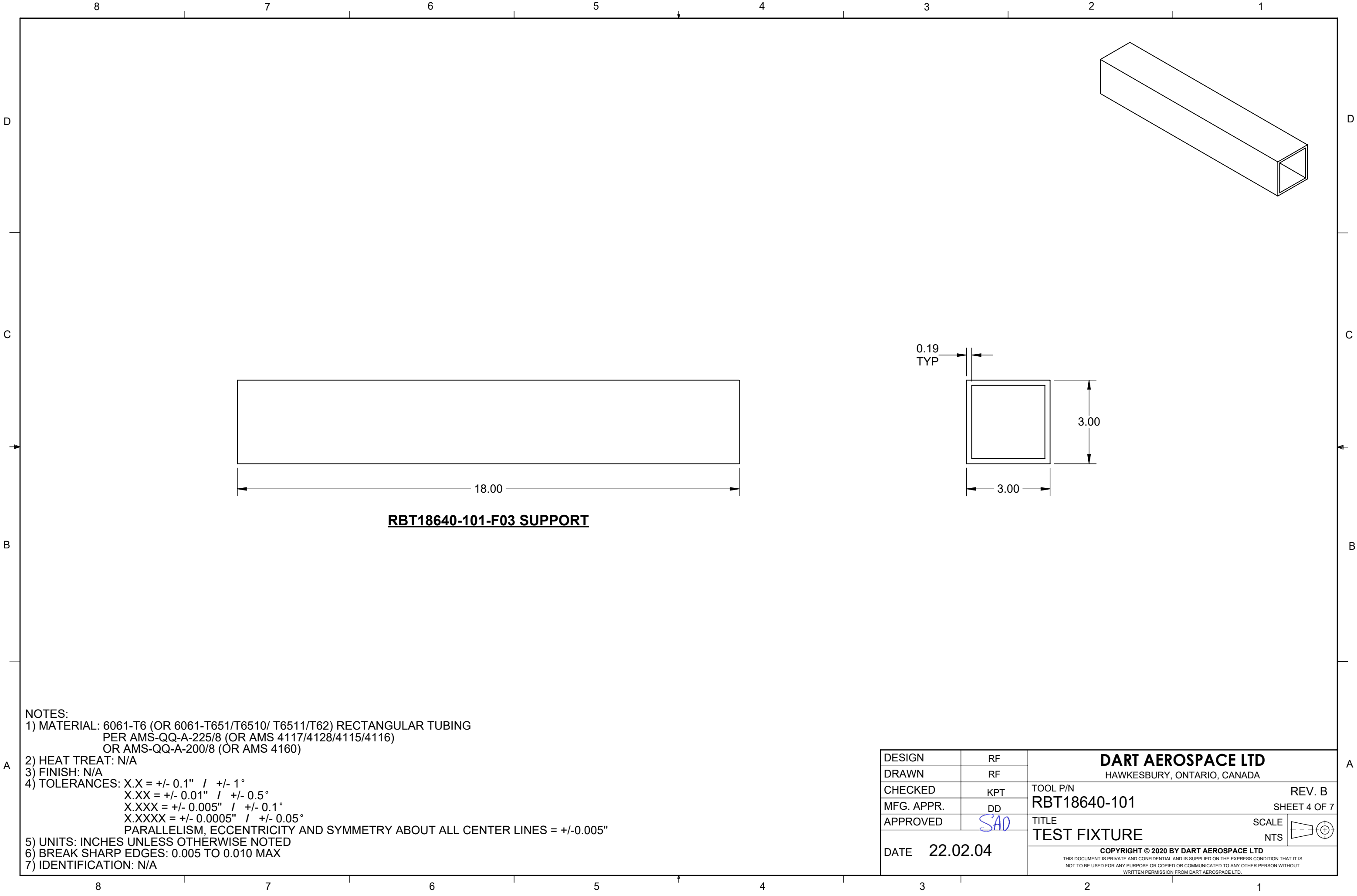
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	KPT	TOOL P/N	REV. B
MFG. APPR.	DD	RBT18640-101	SHEET 2 OF 7
APPROVED	<i>SAO</i>	TITLE	SCALE
DATE 22.02.04		TEST FIXTURE	NTS 
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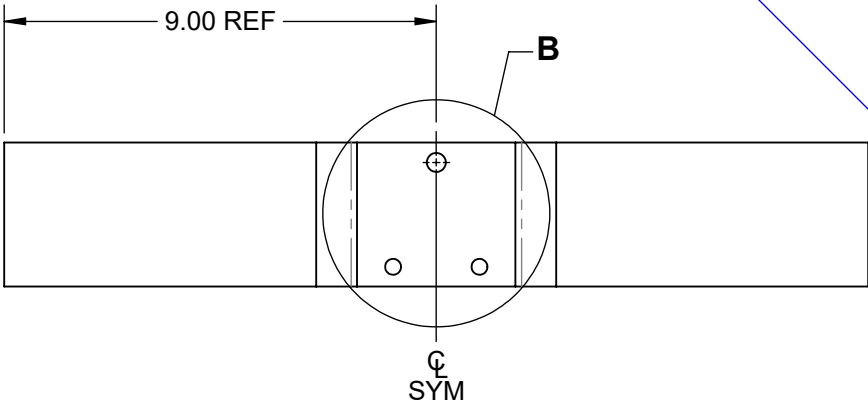
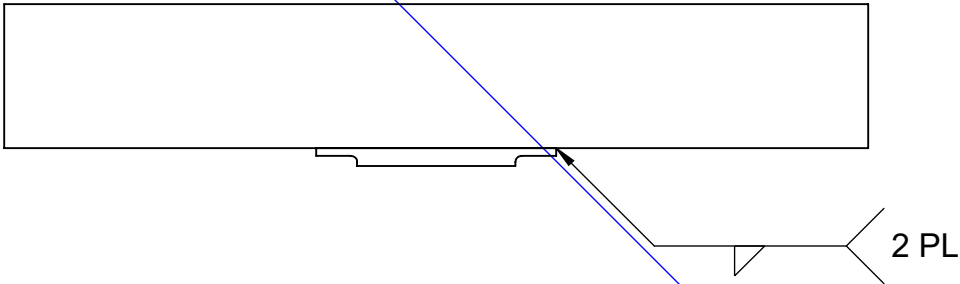
RBT18640-101-F02 TUBE

NOTES:
1) MATERIAL: 6061-T6/T62/T6510/T6511 SEAMLESS TUBING
PER WW-T-700/6
OR QQ-A-200/8 OR QQ-A-225/8
OR AMS 4080 OR AMS 4082 OR AMS 4083
OR ASTM B210 OR ASTM B241
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
7) IDENTIFICATION: N/A

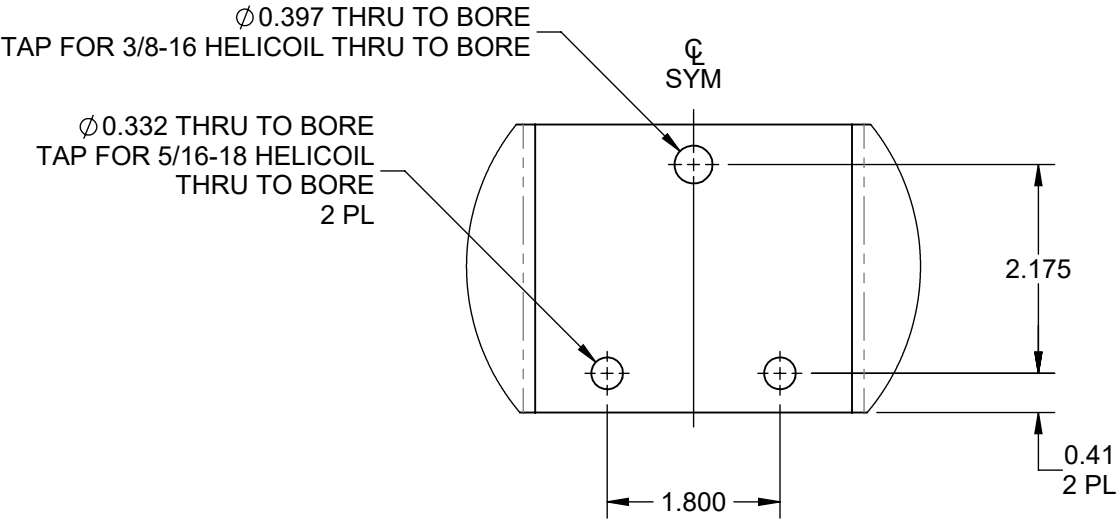
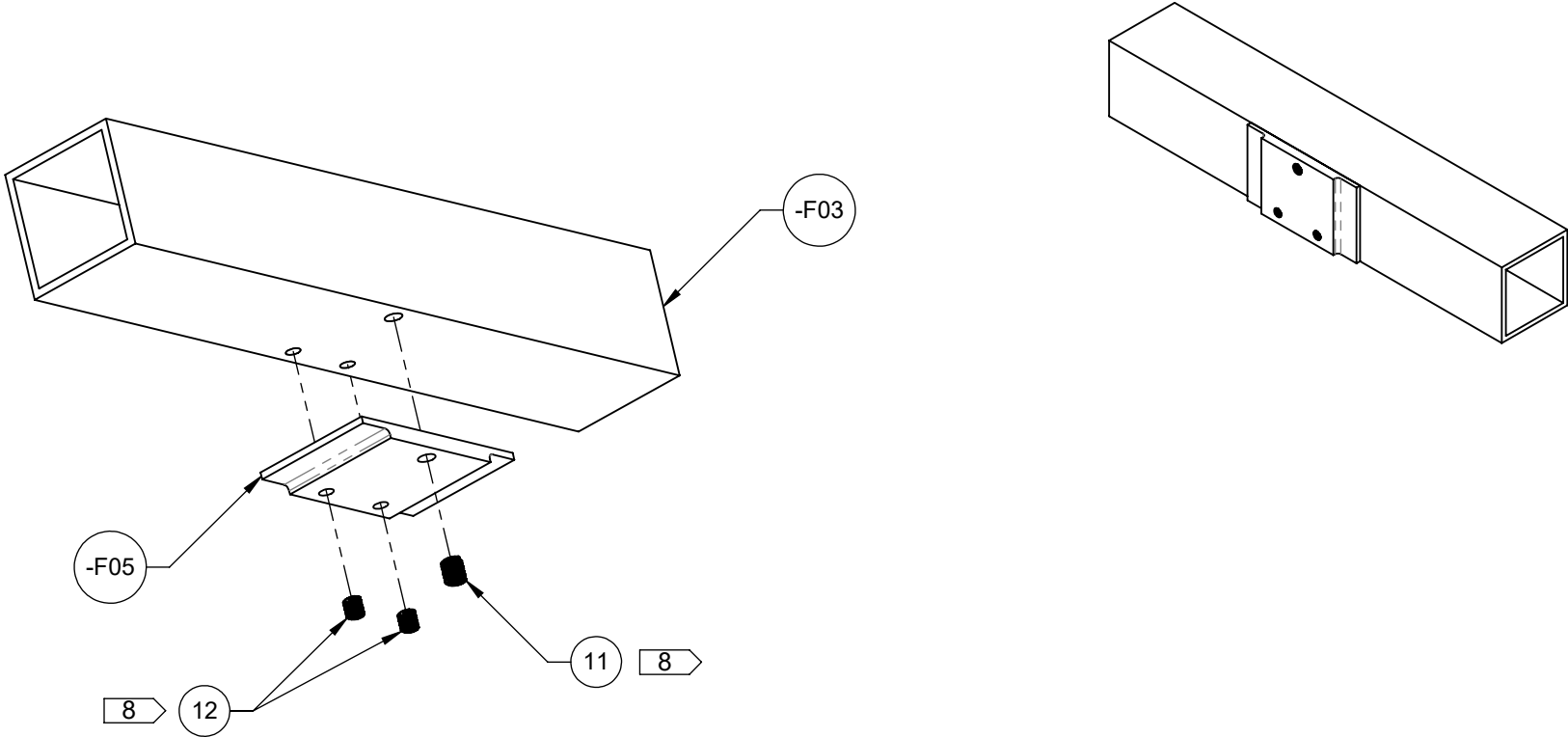
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	KPT	TOOL P/N	REV. B
MFG. APPR.	DD	RBT18640-101	SHEET 3 OF 7
APPROVED	SAO	TITLE	SCALE
DATE 22.02.04		TEST FIXTURE	NTS
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ITEM	QTY	P/N	DESCRIPTION
-F03	1	RBT18640-101-F03	SUPPORT
-F05	1	RBT18640-101-F05	ADAPTER
11	1	MS122123	HELICAL INSERT
12	2	MS122122	HELICAL INSERT



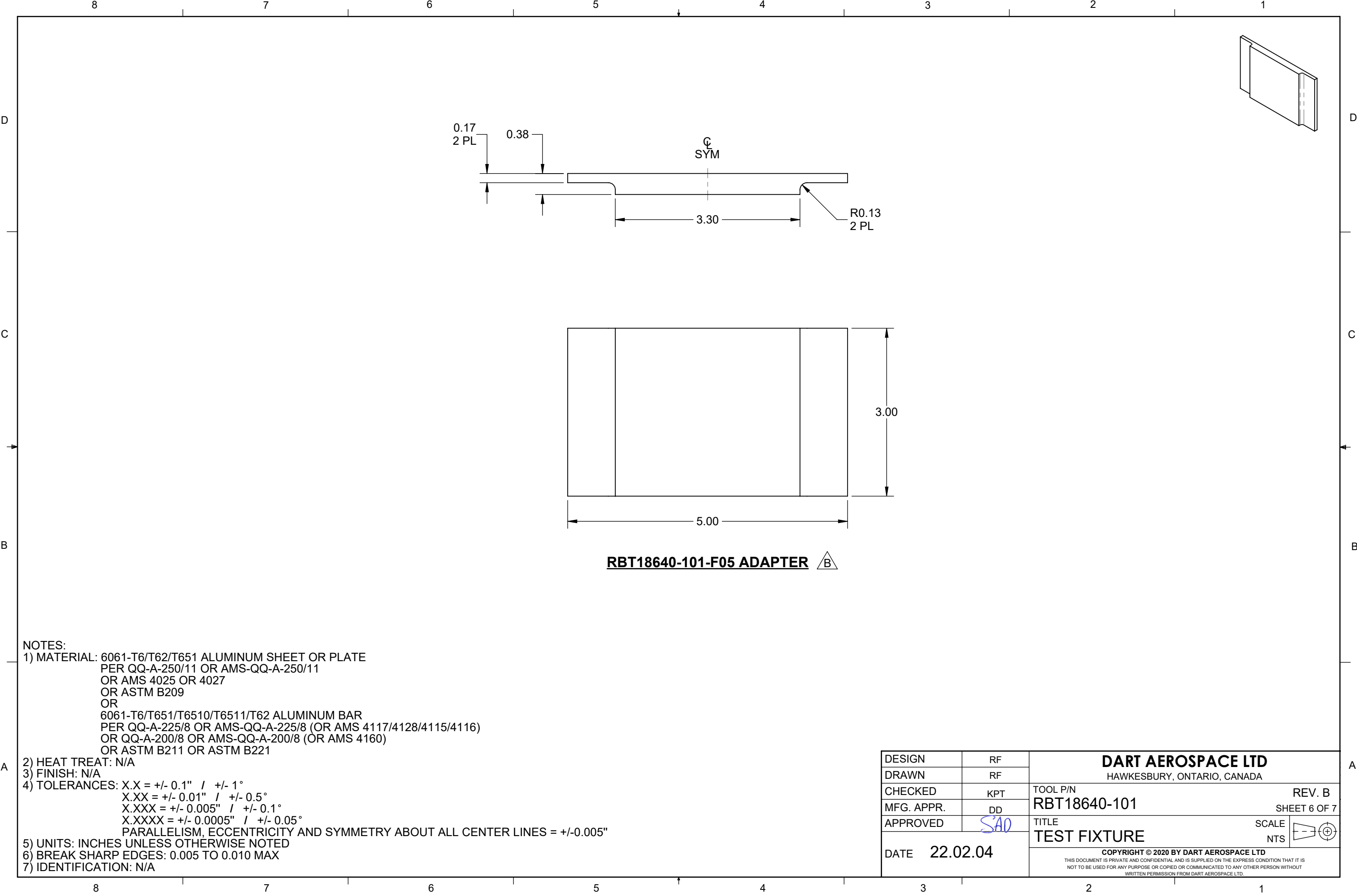
RBT18640-101-F04 ADAPTER PLATE ASSEMBLY 
(HELICAL INSERTS HIDDEN FOR CLARITY)



DETAIL B
(HELICAL INSERTS HIDDEN FOR CLARITY)

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 7) IDENTIFICATION: N/A
 - 8) REMOVE TANG FROM HELICAL INSERT AFTER INSTALLATION

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	KPT	TOOL P/N	REV. B
MFG. APPR.	DD	RBT18640-101	SHEET 5 OF 7
APPROVED	SAD	TITLE	SCALE
DATE 22.02.04		TEST FIXTURE	NTS
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NOTES:
1) MATERIAL: 6061-T6/T62/T651 ALUMINUM SHEET OR PLATE
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR 4027
OR ASTM B209
OR
6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
7) IDENTIFICATION: N/A

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	KPT	TOOL P/N	REV. B
MFG. APPR.	DD	RBT18640-101	SHEET 6 OF 7
APPROVED	SAO	TITLE	SCALE
DATE 22.02.04		TEST FIXTURE	NTS
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